

Date: Thursday, 19/03/2009 11:03:31 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID
Job Number	: 46576	Part Number	: D206642311
Estimate Number	: 10549	Drawing Number	: N/A
P.O. Number	:	Project Number	: N/A
This Issue	: 19/03/2009 S.O. No. :	Drawing Revision	: L
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SKIDTUBES	Due Date	: 15/04/2009 Qty: 1 Um: Each
Previous Run	: 46575		
Written By	: <u>JUD 09.03.19</u>		
Checked & Approved By	: <u>JUD 09.03.19</u>		
Comment	: Est Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC Est Rev:K 07-12-04 ECN 1080p DD verified by:ec Est Rev:L 08-09-29 as per DSI9421 DD verified by:ec Est Rev:M 09-03-02 as per DSI9440 rev.a DD verified by: Est Rev:N 09-03-03 as per DSI9421 rev.b DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

809/04/16

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	46576A	206 L HIGH GEAR SKIDTUBE
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**Comment:** Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE1 x D206-642-341 Batch 46576A

88 09/04/16 (X)

4.0	D206648013	GHW Modification
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification

batch: 43410

88 09/04/16 (X)

5.0	AN4C5A	BOLT
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

batch: M104936

88 09/04/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:03:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46576

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

washer

batch:

M160993

7.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Ring

batch:

33949

8.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Pick:

Qty Part Number Description Batch

16 D2652 Bushing

1 D206-642-341(REF)

45318

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

SET SCREW

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

43810

10.0

D29321

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2932-1 Saddle

B45262

11.0

D29331

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

42978

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:03:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46576

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2933-1 Saddle

12.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description	Batch
2	D2934	Saddle Spacer	44296

88 09/04/16 (X)

13.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description	Batch
2	D2935	Saddle Spacer	44553

88 09/04/16 (X)

14.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2938-1	Saddle	44554

88 09/04/16 (X)

15.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2939-1	Saddle	43188

88 09/04/16 (X)

16.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch: 43308

88 09/04/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:03:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46576

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: 43002

18.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 44003

19.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: M11177

20.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

8

AN3-41A

Bolt

M111163

21.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

12

AN4-6A

Bolt

M110399

22.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

Qty

Part Number

Description

M110363

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:03:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46576

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-10A Bolt
(or AN5-11A)

Choice of bolt will depend on crosstube

23.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4 AN5-11A Bolt

(or AN5-12A)

Choice of bolt will depend on crosstube

M110363

8809/04/16(x)

24.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M110485

8809/04/16(x)

25.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

24 AN960JD416

Washer

M110363

8809/04/16(x)

26.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number

Description

Batch

8 AN960JD516

Washer

M110523

8809/04/16(x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:03:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46576

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

NUT

Pick:

Qty

Part Number

Description

Batch

8

MS21042L3

Nut

M110844

28.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

NUT

Pick:

Qty

Part Number

Description

Batch

13

MS21042L4

Nut

M109282

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-311

Location:

PPP Rev:

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-18

46576A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 12:51:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID
 Job Number : 46576
 Estimate Number : 10549
 P.O. Number :
 This Issue : 23/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 19/03/2009 Type : SKIDTUBES
 Previous Run : 46575
 Part Number : D206642311
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : L
 Material :
 Due Date : 15/04/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC

REFERENCE ONLY

Est Rev:K 07-12-04 ECN 1080p DD verified by:ec
 Est Rev:L 08-09-29 as per DSI9421 DD verified by:ec
 Est Rev:M 09-03-02 as per DSI9440 rev.a DD verified by:
 Est Rev:N 09-03-03 as per DSI9421 rev.b DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

JUD 09.04.16 / 802604/16



2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit



3.0 46576A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE

1 x D206-642-341 Batch



Job Completion

